
Friday, July 22, 2011 2:53:44 PM

Accept

**Setup Start**

Stop

**Cust Item ID:**

Customer:

Reference:

Run Start

Date: 11-07-22

Tooling: _____ **Date:** _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Date: _____ **SPC (Y/N):** _____ **Date:** _____

Draw Nbr	Revision Nbr
D3270	Rev B

100

0.00

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3270 ☐ Dwg Rev: 5 ☐ Prog Rev: 13 ☐ 2-Debur
if necessary

6061 . 040

110

QC8- Inspect parts - second check

0.00

Abstract

QC

Memo

0.00

Quality Control

120

QC2- Inspect parts off machine FAI/FAIB

0.00

[illegible]

QC

Memo

0.00

Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72362

Friday, July 22, 2011 2:53:44 PM



Page 2

Item ID: D3270-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Base

Start Date: 7/22/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

1-Deburr if necessary 2-Form D3270-1 and drill holes using D3270-1T1 as per Dwg D3270

5/10/31 18

140



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

11 10 31 18

150



Packaging

Identify as per dwg & Stock Location LWA

0.00

Memo

0.00

Packaging

*****STOCK IN LARGE FAB*****

11/10/31 18

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 72362

Page 3

Friday, July 22, 2011 2:53:44 PM

Item ID: D3270-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Base

Start Date: 7/22/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/11/10 [Signature]

JMF 11-10-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, July 22, 2011 2:53:50 PM

Page 1

Work Order ID: 72362



Parent Item: D3270-1



Parent Item Name: Mounting Base

Start Date: 7/22/2011

Required Date: 7/29/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev: A New Issue 05-11-01 JLM
IPP Rev: B now water jet 08-01-24 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased	No			110	sf	105.5000	0.0374	0.236211	1		

6061-T6 .040 Sheet

Location

Loc Qty

Loc Code

MAT021

105.5

113004

9.5

117653

96

117653

18

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

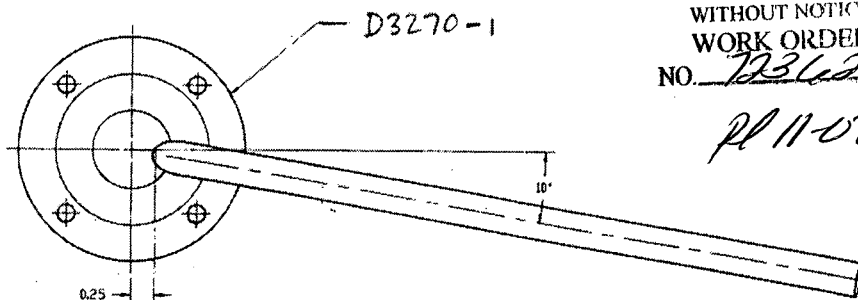
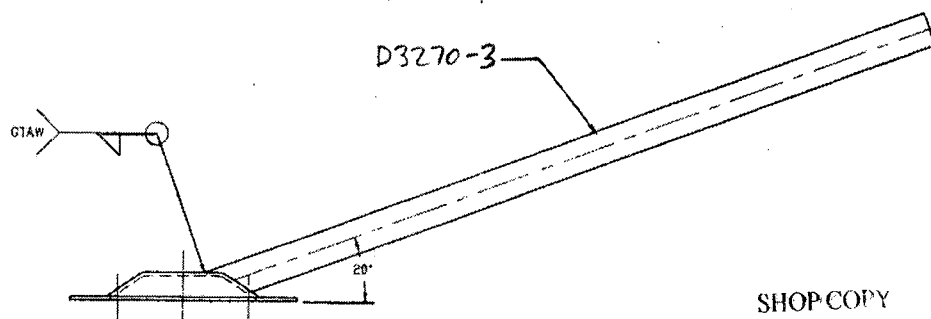
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NOTE: Date & initial all entries



DESIGN	<i>[Signature]</i>	DRAWN BY	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>UP</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3270	REV. B SHEET 1 OF 2
DATE	05.07.14			TITLE FUEL SCUPPER DRAIN ASSEMBLY	SCALE NTS
A	04.02.20			NEW ISSUE	
B	05.07.14			ADD D3270-1 FLAT PATTERN	

RELEASED
04.02.23 *[Signature]*



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *12362*

PL 11-07-22

D3270-041 FUEL SCUPPER ASSEMBLY

- NOTES:
- 1) WELD PER DART QSI 004 USING 5356 FILLER ROD.
 - 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT GLOSS WHITE (REF. 4.3.5.1) PER QSI 005 4.3
 - 3) ALL DIMENSIONS ARE IN INCHES
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 5) CONTOUR MAY BE ALTERED TO DOMED SHAPE AT FABRICATOR'S DISCRETION

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

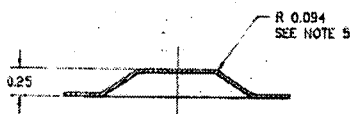
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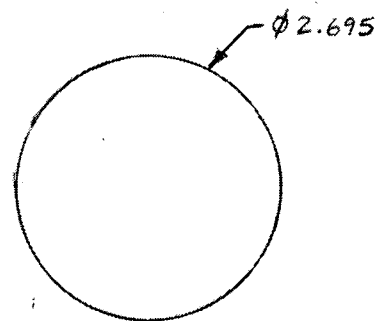
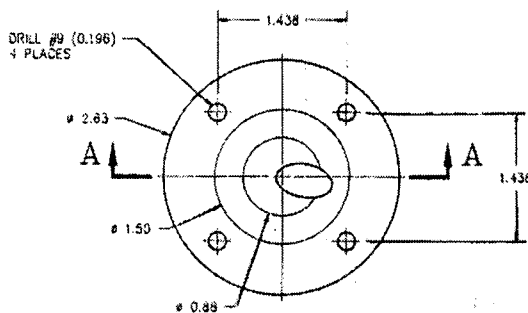


DESIGN	<i>HA</i>	DRAWN BY	<i>HA</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>CP</i>	APPROVED	<i>HA</i>	DRAWING NO. D3270 REV. B SHEET 2 OF 2
DATE	05.07.14	TITLE	FUEL SCUPPER ASSEMBLY	SCALE MT3
A	04.02.20	NEW ISSUE		
B	05.07.14	ADD D3270-1 FLAT PATTERN		

RELEASED
04.02.23 *HA*



SECTION A-A

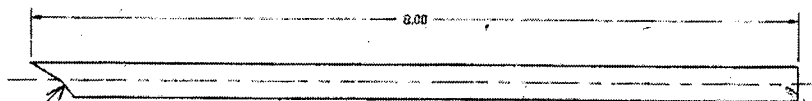


D3270-1 FLAT PATTERN

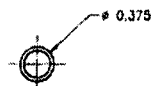


D3270-1 MOUNTING BASE

MATERIAL: 6061-T6 ALUMINUM SHEET 0.040" THICK PER QQ-A-250/11 (M6061T6S.040)



CHAMFER TO FIT
D3270-1



D3270-3 FUEL OUTLET TUBE

MATERIAL: 6061-T6 ALUMINUM TUBING 0.375" OD X 0.035" WALL (SEAMLESS)
PER MW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8
(M6061T6T0.375W.035)

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